

Date: Friday, 30/11/2007 8:22:03 AM
User: Linda Lacelle

Process Sheet

| | |
|--|---|
| Customer : CN-DAR001 Dart Helicopters Services | Drawing Name : CONSOLE ASSEMBLY |
| Job Number : 36074 | |
| Estimate Number : 11224 | |
| P.O. Number : | Part Number : D206547043 |
| This Issue : 30/11/2007 S.O. No. : | Drawing Number : D206-547 REV F |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : F |
| Previous Run : 33905 | Material : |
| Written By : | Due Date : 07/12/2007 Qty: 10 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev: I 06-07-05 Removed Packing Kit JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------|--------------------|
| 1.0 | D2024 | Extrusion, Console |
|-----|-------|--------------------|



Comment: Qty.: 3.5910 Each(s)/Unit Total: 35.9100 Each(s)

D2024 Extrusion

Batch M2 7

FF 07-11-30 10

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 07-12-30 10

| | | |
|-----|--------|-----------------------|
| 3.0 | D26021 | Console Side Hi Slope |
|-----|--------|-----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|-------|
| Qty Part Number | Description | Batch |
|-----------------|-------------|-------|

| | | |
|-----------|---------|---------|
| 1 D2602-1 | Side LH | B 33906 |
|-----------|---------|---------|

FF 07-12-03

| | | |
|-----|--------|-----------------------|
| 4.0 | D26022 | Console Side Hi Slope |
|-----|--------|-----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

| | | |
|-----------------|-------------|-------|
| Qty Part Number | Description | Batch |
|-----------------|-------------|-------|

| | | |
|-----------|---------|---------|
| 1 D2602-2 | Side RH | B 33907 |
|-----------|---------|---------|

FF 07-12-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

*Date: Friday, 30/11/2007 8:22:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 36074

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B 33908

26

B 36081

FF

07-12-03

(10)

6.0

D2607

Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

B 33909

28

B 32820

FF

07-12-03

(10)

7.0

MS20470AD33

Rivet,Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

M 1065

FF

07-12-03

10

8.0

MS20470AD34

Rivet,Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M 15541

FF

07-12-03

10

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF

07-12-19

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:22:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 36074

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/21 X10-2
X10-1

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: M104855

2008-05-08 X10

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/5/12 X10

13.0

QC5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

508/5/12 X10

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

mlo8/05/14 X10

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/05/14 X10 30min 15/05/2008

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M105642

M-1 08/05 #1 312.7 #2 1336074 #3 12206547043 #4

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15 X10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 30/11/2007 8:22:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 36074

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

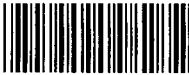
Location: PPP. 36075

JS 08/05/16 (X10)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2009

Job Completion



UMF 08-05-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED UP | APPROVED KE | DRAWING NO. D206-547 | REV. F SHEET 1 OF 5 |
| DATE 99.02.11 | | TITLE CONSOLE ASSEMBLY | SCALE NTS |
| - | 82.11.23 | NEW ISSUE | |
| A | 83.01.18 | REDRAWN, ADD NOTE 4 | |
| B | 84.10.23 | D206-547 WAS 01.B.81.017 | |
| C | 89.03.30 | REDRAWN | |
| D | 90.12.06 | COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85 | |
| E | 97.10.22 | REDRAWN, ADD -043,-045,-047 | |
| F | 99.02.11 | ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL | |

RELEASED
99.03.05 RE

| -041 | -043 | -045 | -047 | PART NUMBER | DESCRIPTION |
|------|------|------|------|--------------|-------------------|
| X | | | | D206-547-041 | CONSOLE ASSEMBLY |
| | X | | | D206-547-043 | CONSOLE ASSEMBLY |
| | | X | | D407-547-045 | CONSOLE ASSEMBLY |
| | | | X | D407-547-047 | CONSOLE ASSEMBLY |
| 1 | | | | D2601-1 | CONSOLE SIDE |
| 1 | | | | D2601-2 | CONSOLE SIDE |
| | 1 | | | D2602-1 | CONSOLE SIDE |
| | 1 | | | D2602-2 | CONSOLE SIDE |
| | | 1 | | D2603-1 | CONSOLE SIDE |
| | | 1 | | D2603-2 | CONSOLE SIDE |
| | | | 1 | D2604-1 | CONSOLE SIDE |
| | | | 1 | D2604-2 | CONSOLE SIDE |
| 1 | | 1 | | D2605 | CONSOLE BRACKET |
| | 1 | | 1 | D2606 | CONSOLE BRACKET |
| 1 | 1 | | | D2607 | CONSOLE BRACKET |
| | | 1 | 1 | D2608 | CONSOLE BRACKET |
| 1 | | 1 | | D2709-1 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-2 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-3 | CONSOLE SIDE RAIL |
| 1 | | 1 | | D2709-4 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-1 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-2 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-3 | CONSOLE SIDE RAIL |
| | 1 | | 1 | D2710-4 | CONSOLE SIDE RAIL |
| 10 | 8 | 8 | 6 | MS20470AD3-3 | RIVET |
| 18 | 20 | 18 | 20 | MS20470AD3-4 | RIVET |

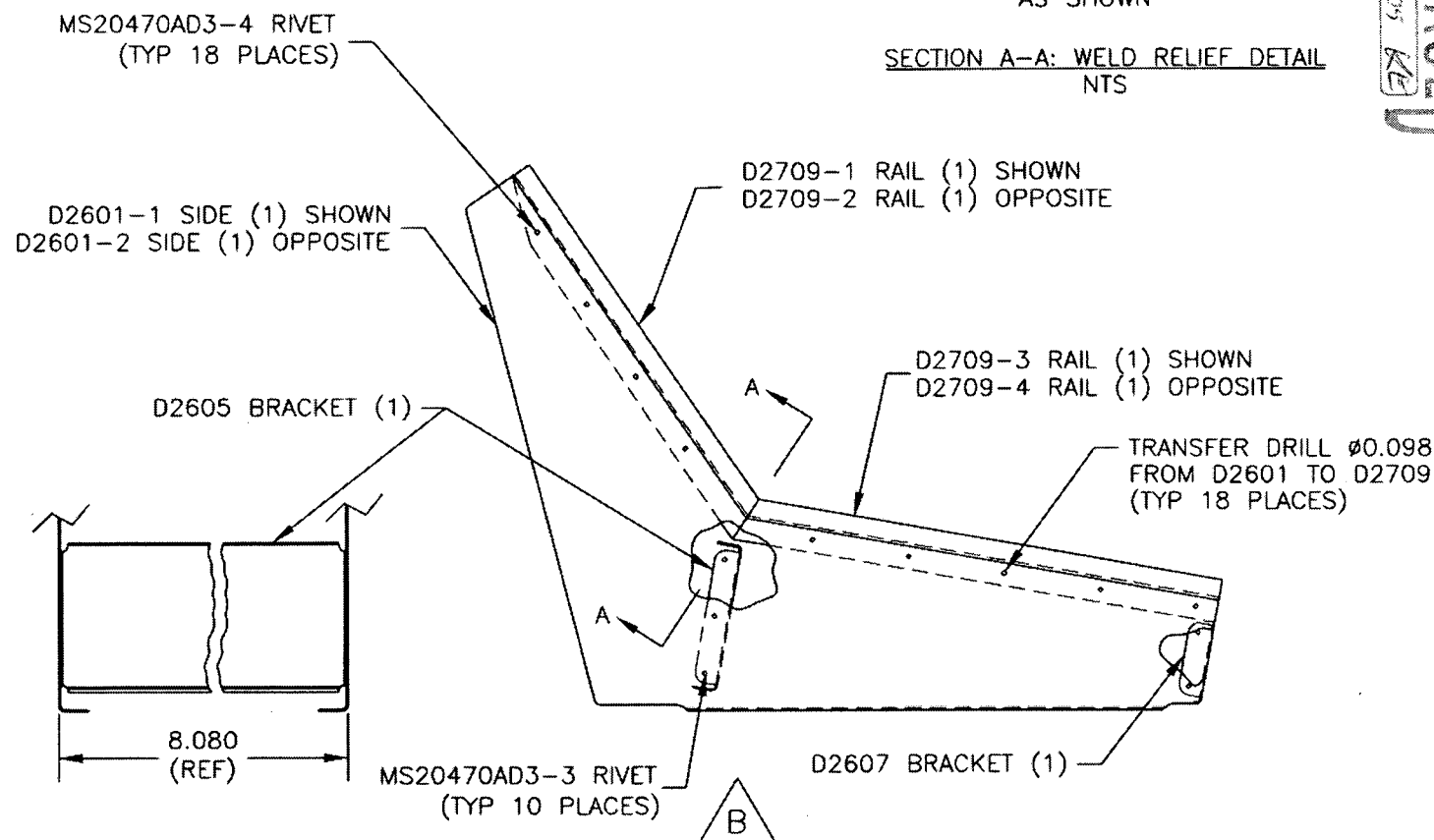
DART

RELEASED
99.02.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | | |
|---------|----------|----------|------------------|---|
| DESIGN | BW | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | JP | APPROVED | KE | |
| DATE | 99.02.11 | TITLE | D206-547 | REV. F |
| | | | CONSOLE ASSEMBLY | SHEET 2 OF 5 |
| | | | | SCALE 1:4 |

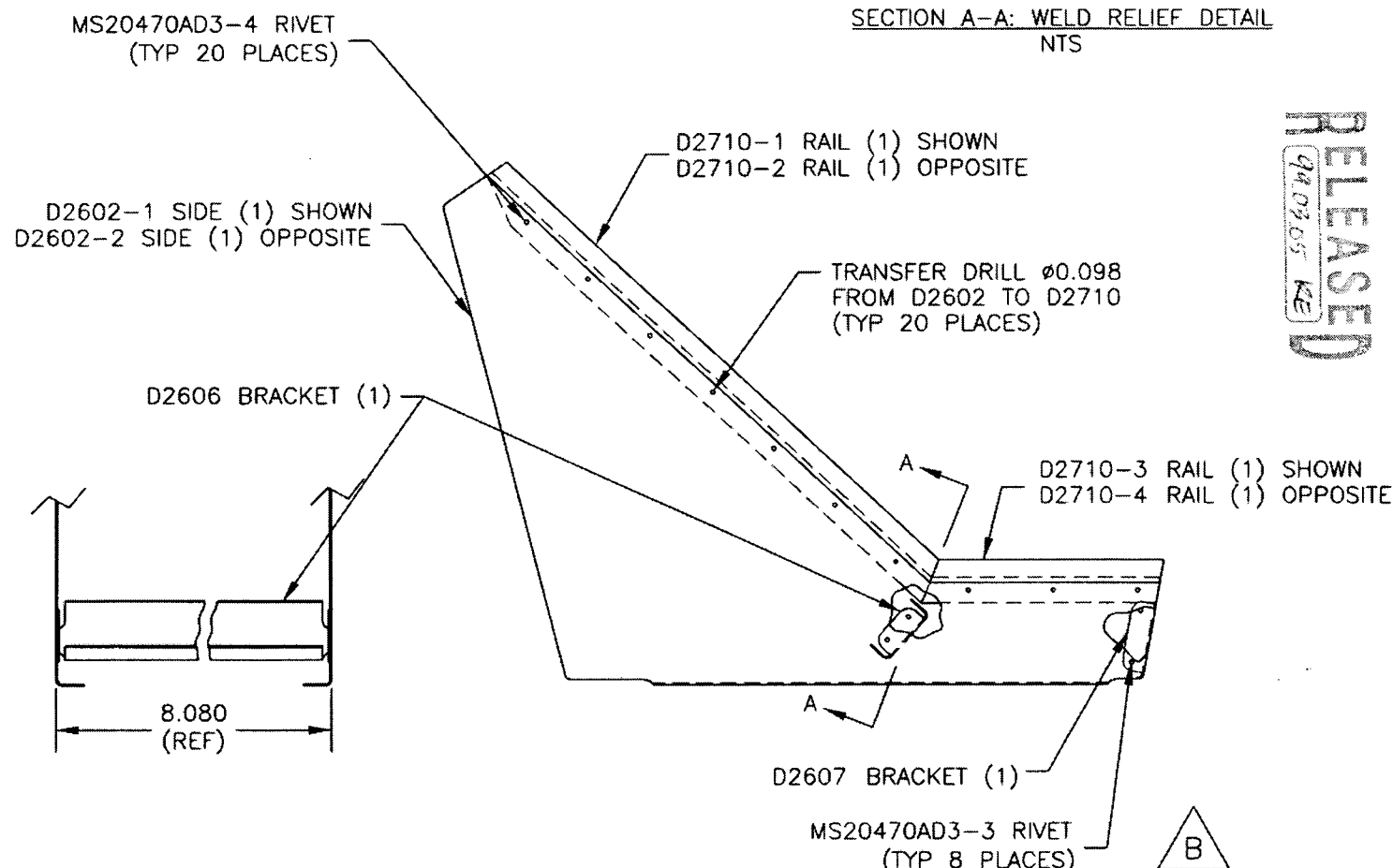
DART

RELEASED
99.02.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

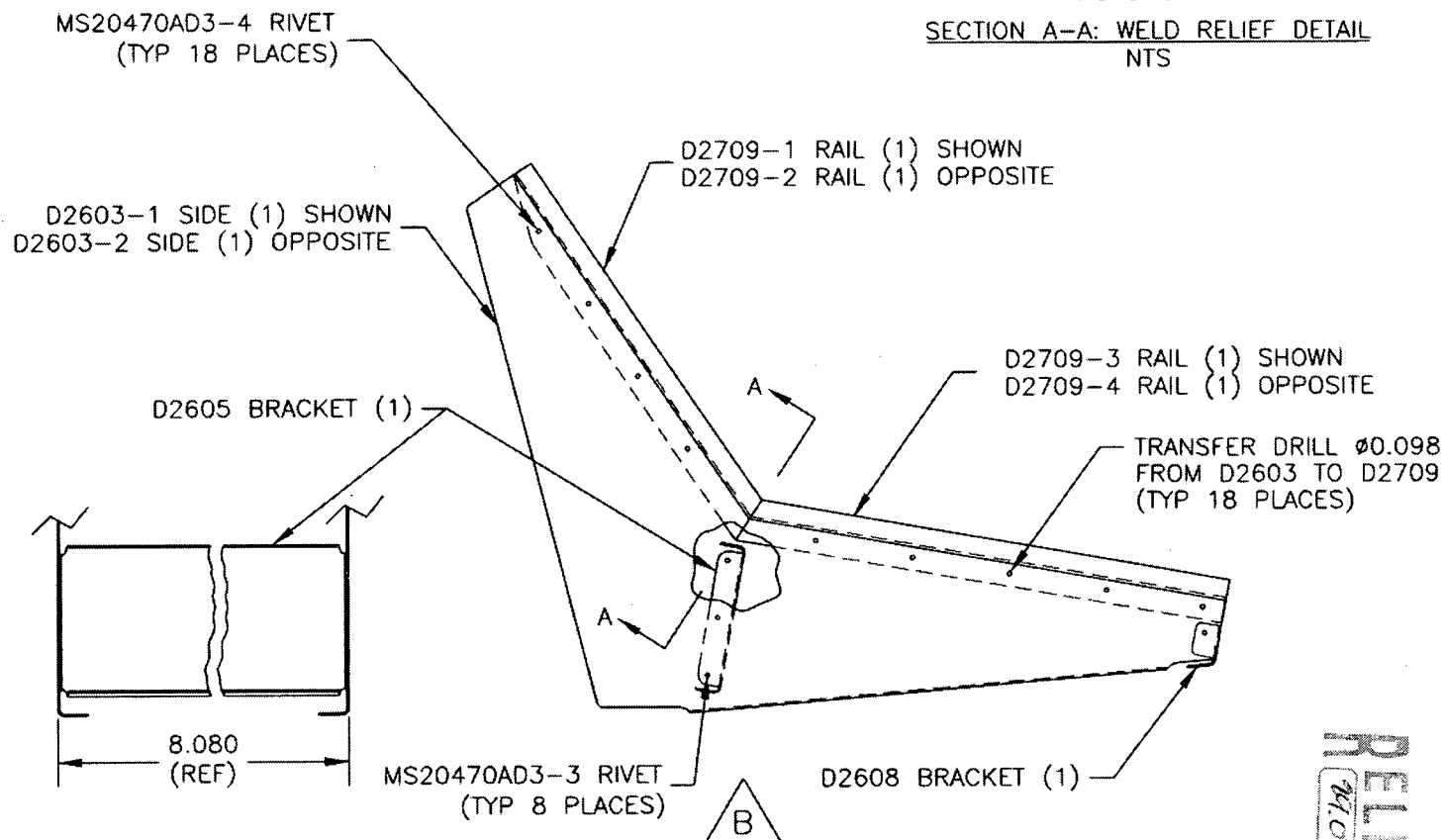
| | | | | |
|---------|----------|-------------|------------------|---|
| DESIGN | BW | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | UP | APPROVED | KE | |
| DATE | 99.02.11 | DRAWING NO. | D206-547 | REV. F |
| | | TITLE | CONSOLE ASSEMBLY | SHEET 3 OF 5 |
| | | SCALE | 1:4 | |

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
M0305 KE

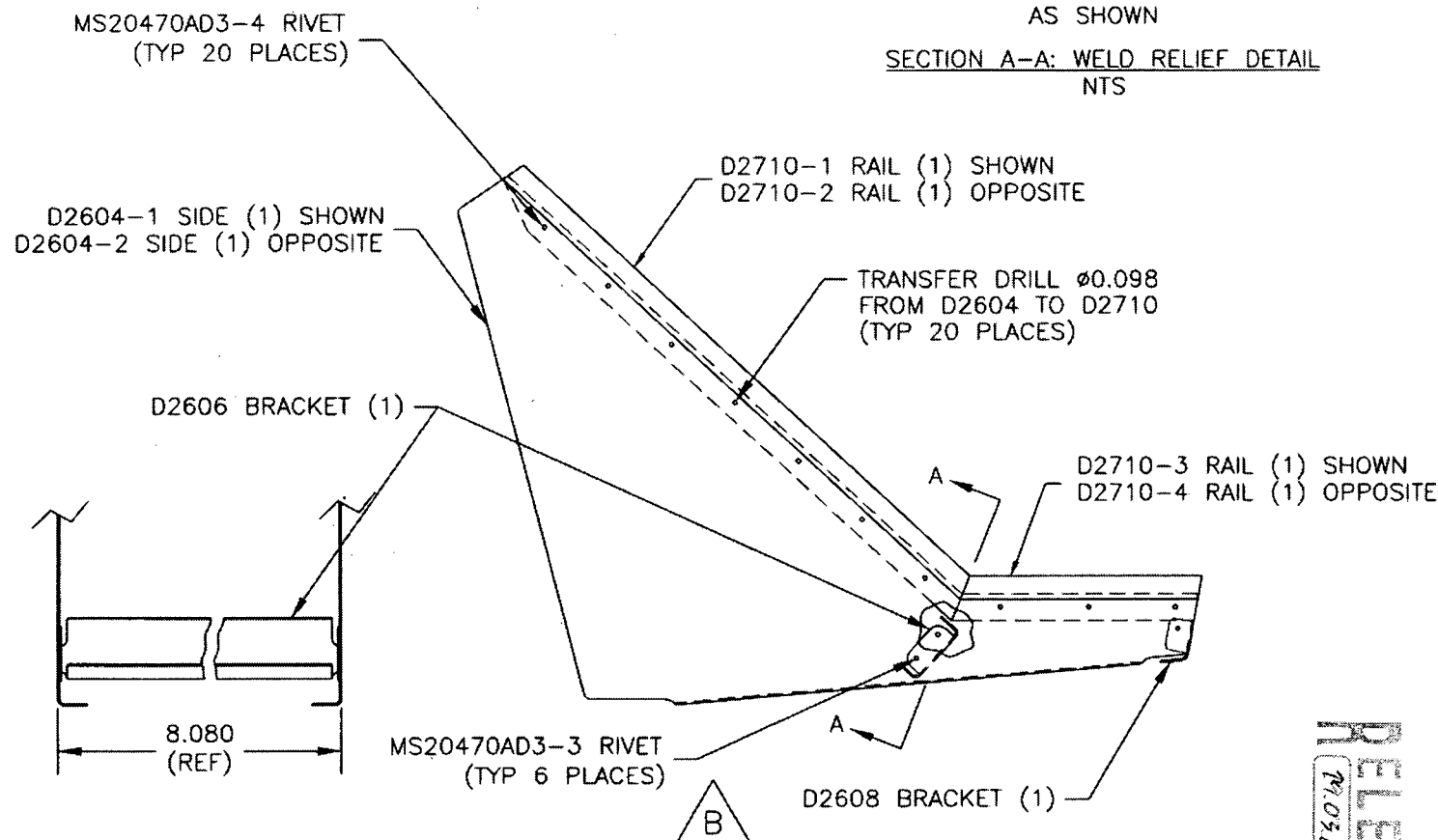
| | | | | |
|---------|----------|----------|------------------|---|
| DESIGN | BW | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | KE | APPROVED | KE | |
| DATE | 99.02.11 | TITLE | D206-547 | SHEET 4 OF 5 |
| | | | CONSOLE ASSEMBLY | SCALE 1:4 |

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
170305 KE

| | | | | |
|---------|----------|-------------|------------------|---|
| DESIGN | BW | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | KE | APPROVED | KE | |
| DATE | 99.02.11 | DRAWING NO. | D206-547 | REV. F |
| | | TITLE | CONSOLE ASSEMBLY | SHEET 5 OF 5 |
| | | | | SCALE |
| | | | | 1:4 |